

Work Order ID 144678

April 21, 2016 3:15:36 PM

144678

Page 1

Item ID: D2813

Revision ID:

Item Name: Washer

Start Date: 5/4/2016

Start Qty: 20.00

20

Required Date: 5/18/2016

Req'd Qty: 20.00

20

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MCS

Date: APR 22 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2813

Rev A

100

1.42

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.60

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA637 & DWG D2813 ,FOLIO
REV: N/A DWG REV: A 2-DEBURR AS REQUIRED

6

Ø

JCL. 16-08-05

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.20

Quality Control

6

Ø

JCL. 16-08-05

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.40

Quality Control

6

Ø

DAS
14
9-09

16/05/05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																									

Work Order ID 144678

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144678

Page 2

Item ID: D2813

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Washer

Start Date: 5/4/2016 Start Qty: 20.00 ***20***

Cust Item ID:

Required Date: 5/18/2016 Req'd Qty: 20.00 ***20***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>81011</u>	0.00							
130									
Packaging	Memo	0.20							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	2.00							
Quality Control									

MCS MAY 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Picklist Print

April 21, 2016 3:15:36 PM

Page 1

Work Order ID: 144678

144678

Parent Item: D2813

D2813

Parent Item Name: Washer

Start Date: 5/4/2016

Required Date: 5/18/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:C Now Turned 06-02-24 JLM
IPP Rev:B00.11.16Changed material EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR2.000		Purchased		No		100	f	9.4400	0.016	0.336842			

MDFI RINR2 000

DELRIN ROUND BAR 2.00"

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	8	
m134332	8	
MAT039	1.44	
104930	1.44	

0.094 J.C.L. 16-05-03

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

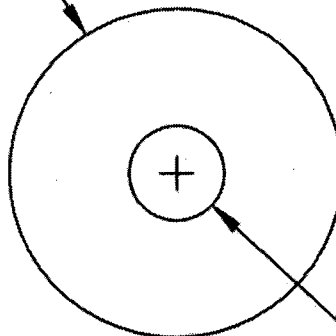
Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							



DESIGN <i>#</i>	DRAWN BY <i>#</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>#</i>	DRAWING NO. D2813	REV. A SHEET 1 OF 1
DATE 00.11.03		TITLE WASHER	SCALE 1:1
A	00.11.03	NEW ISSUE	

RELEASED
00.11.13 *#*

Ø1.80



STOP COPY
RETURN TO
PROTECTOR
UNCONTROLLED COPY
SUBJECT TO A FIRM'S
WITHOUT NOTICE
WORK ORDER
NO. 144678 M5
16-04-22

Ø0.516

MATERIAL: DELRIN OR TEFLON OR UHMW 0.063 THICK
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
THIS PART CAN BE MADE FROM D2551

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